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(56) Documents Cited  
GB 2323399 A EP 0915230 A  
US 5971353 A US 5285850 A  
US 5251702 A US 4201363 A

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(54) Abstract Title  
Control of subsurface isolation valve

(57) A method and apparatus of isolating a reservoir of production fluid in a formation providing at least one valve 14, 16 in a bore intersecting a production formation in which the hydrostatic pressure in the bore at the formation is normally lower than the formation pressure, and then controlling the valve or valves from the surface such that they will only move from a closed to open configuration on experiencing a predetermined differential pressure across the valve/s.

Additionally an apparatus for use in isolating a reservoir of production fluid in a formation comprising a valve and valve control means, the valve having two valve closure members adapted to hold pressure from above and below.

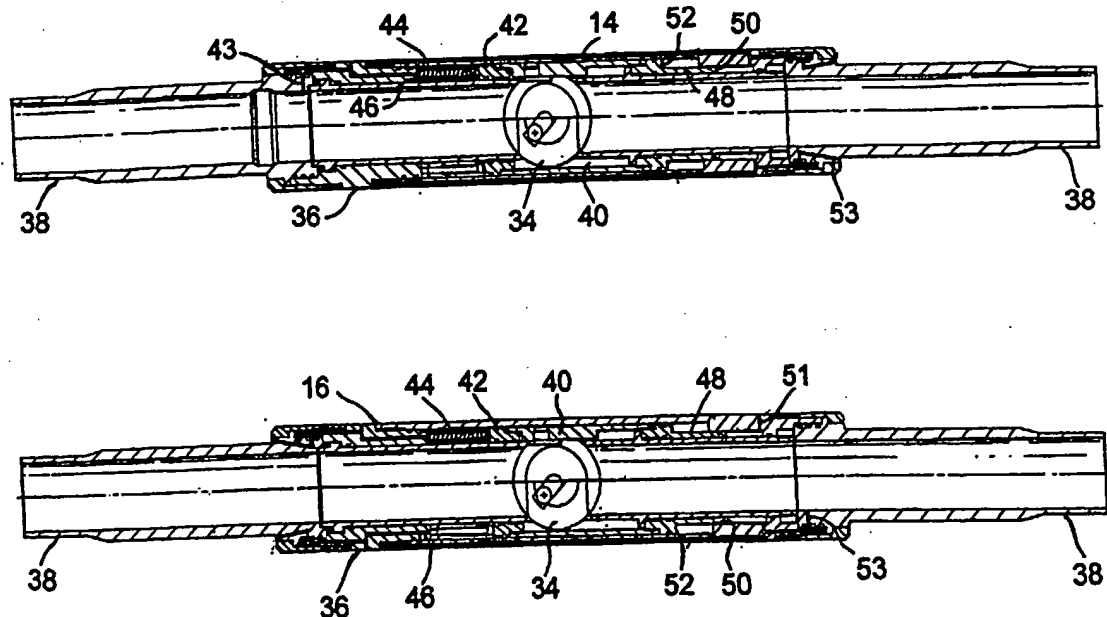


Fig.2

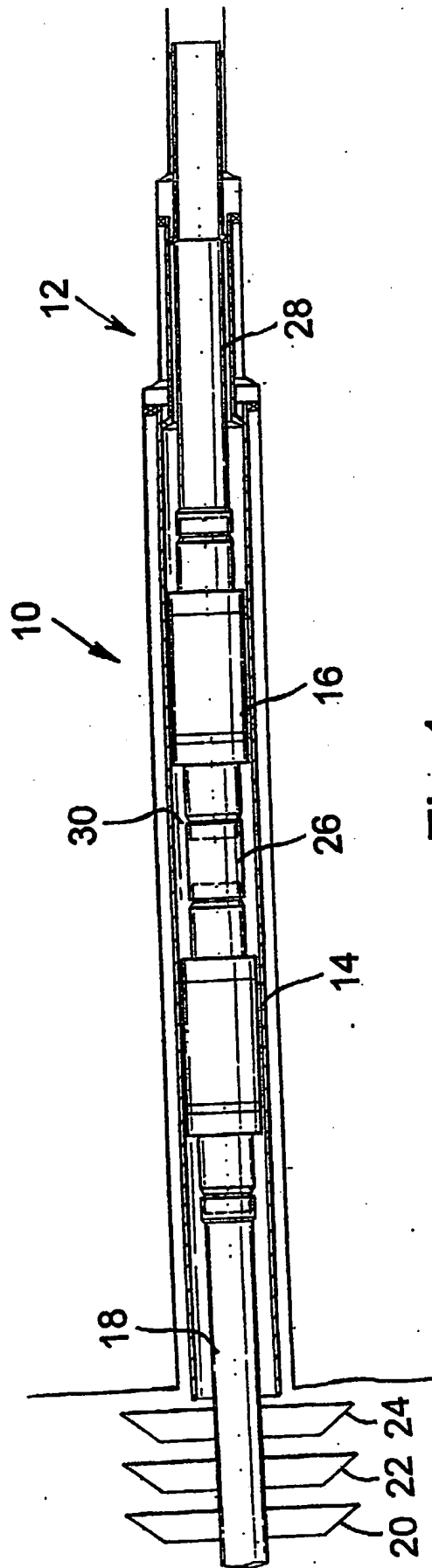


Fig. 1

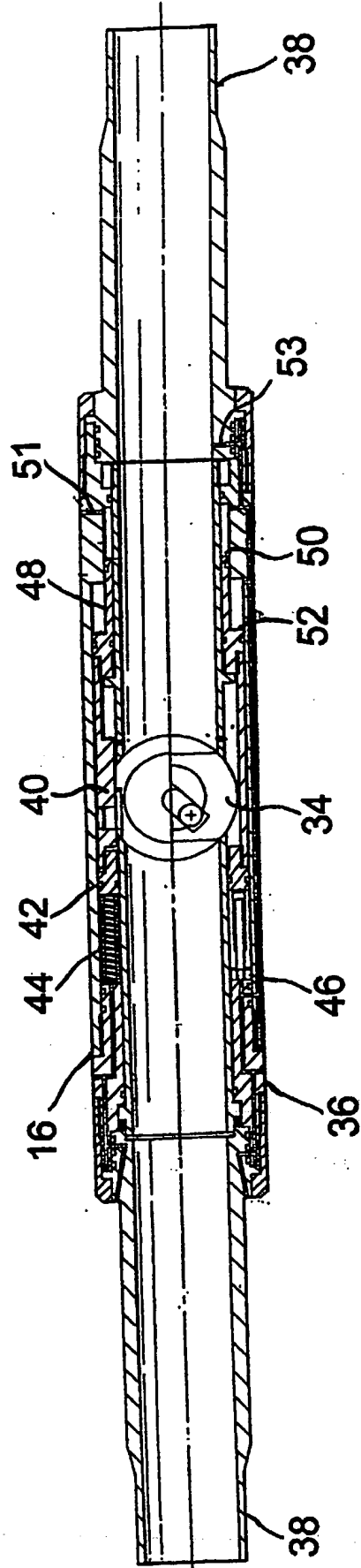
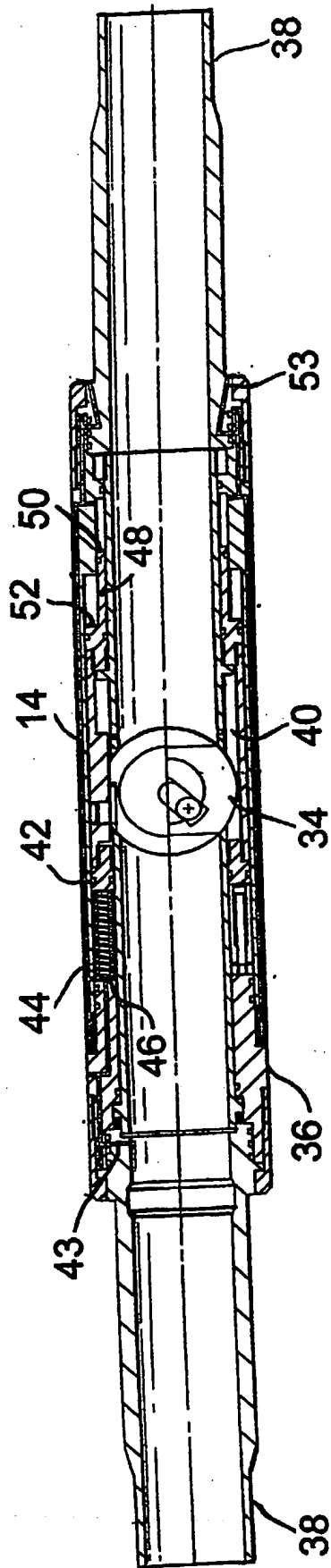


Fig.2

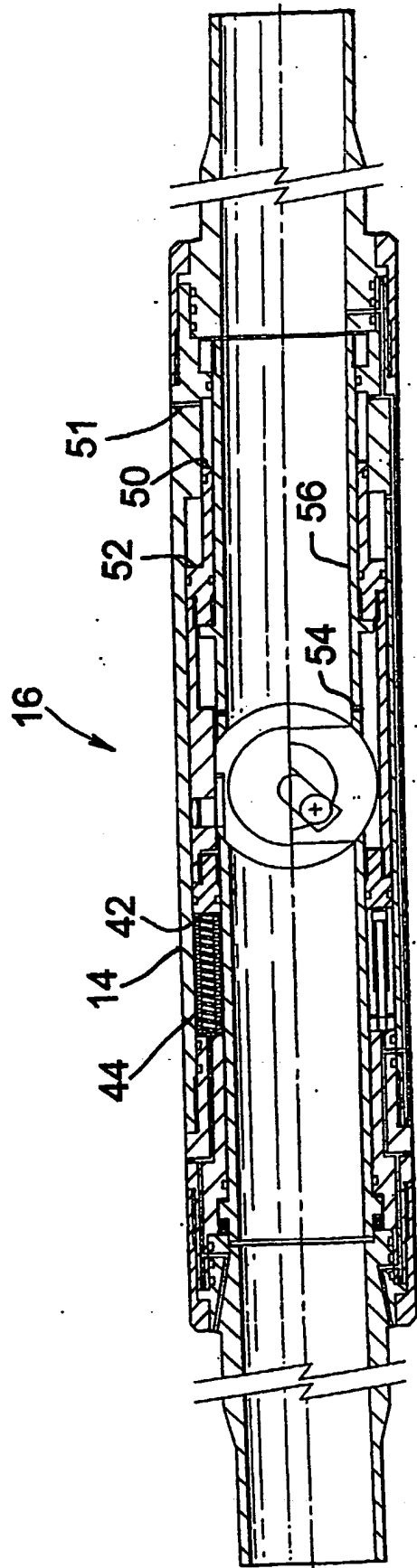


Fig. 3

WELL CONTROL

This invention relates to well control, and in particular to a method and apparatus for use in controlling access and flow to and from a subsurface well.

5 In the oil and gas exploration and production industry, bores are drilled to access subsurface hydrocarbon-bearing formations. The oil or gas in the production formation is under pressure, and to prevent uncontrolled flow of oil or gas from the formation to the surface, that is a "blowout", it has been conventional to  
10 fill the bore above the formation with fluid of sufficient density that the hydrostatic pressure head provided by the column of fluid retains the oil or gas in the formation. However, it has been recognised that this practice may result in damage to the formation, and may significantly  
15 reduce the productivity of the formation. This problem has recently come to the fore as deeper and longer bores are drilled, and thus the hydrostatic pressure of drilling fluid or "mud" increases, and further as the pressures necessary to circulate drilling fluid and entrain cuttings  
20 in the conventional manner increases.

One result of these experiences and findings has been the development of technology and methods which permit "under-balanced" drilling, that is a drilling operation in

which the pressure of the drilling fluid is lower than the formation fluid pressure, such that oil and gas may flow from the formation and commingle with the drilling fluid. The fluids travel together to the surface and are separated at surface. In many cases, use of underbalanced drilling has resulted in marked increases in well productivity.

However, one difficulty associated with underbalanced drilling is the relatively high fluid pressures that are experienced at surface. This places an increased reliance on surface sealing arrangements, and generally increases the difficulty in controlling the well; the conventional high density fluid column is not present, and in the event of difficulties, pumping higher density fluid into the well to "kill" or control the well may take some time and is likely to result in damage to the formation, perhaps to an extent where the well must be abandoned.

There is also a difficulty associated with making up drill string and the like to be run into such wells, or indeed in any well where the pressure at surface is relatively high. In such wells, the relatively high fluid pressure (which may be several hundred atmospheres) will tend to push the drill string up and out of the well, such that making up such a string becomes a difficult and potentially dangerous operation. This difficulty persists until the weight of the string is sufficient to counteract the pressure force.

It has been proposed to avoid or overcome at least some of these difficulties by placing a flapper valve in a lower section of a well, the valve closing when the pressure forces acting from below the valve are greater than the pressure forces acting from above the valve. This places restrictions of the placement of the valve which, to be effective, must be located close to the pressure balance point in the well, that is the point where the upward acting fluid pressure force, or reservoir pressure, equals the downward acting force from the pressure head produced by the column of fluid in the bore. Further, while such a valve may assist in preventing uncontrolled flow from a formation, the valve will not serve to protect a formation from damage or contamination in the event that the pressure above the valve rises; in such a situation elevated pressure above the valve will tend to open the valve. Similarly, testing the valve presents difficulties, as higher test pressures will tend to open the valve, and therefore no pressure greater than reservoir pressure may be safely utilised, as a higher pressure would run the risk of damaging the formation.

It is among the objectives of embodiments of the present invention to obviate or mitigate these disadvantages.

According to one aspect of the present invention there is provided a method of isolating a reservoir of production

fluid in a formation, the method comprising:

providing a valve in a bore intersecting a production formation and in which the hydrostatic pressure in the bore at the reservoir is normally lower than the formation pressure; and

controlling the valve from surface such that the valve will only move from a closed configuration to an open configuration on experiencing a predetermined differential pressure thereacross.

The invention also relates to an apparatus for use in isolating a reservoir of production fluid in a formation, the apparatus comprising:

a valve adapted for location in a bore intersecting a production formation and in which the hydrostatic pressure in the bore at the reservoir is normally lower than the formation pressure;

first valve control means for permitting control of the valve from surface; and

second valve control means for permitting control of movement of the valve from a closed to an open configuration in response to a predetermined differential pressure across the valve.

Preferably, the valve is controlled such that it will only open when there is little or no pressure differential across the valve. In under-balanced and live well applications this allows the valve to hold pressure from



one or both sides, and minimises the risk of formation damage or contamination when the pressure above the valve is higher than the pressure below the valve. Further, this feature may be utilised to minimise the risk of uncontrolled flow of fluid from the formation, in the event of pressure below the valve being higher than the pressure above the valve.

The valve may be positioned above, at or below the pressure balance point.

Preferably, the valve is controlled from surface by fluid pressure, the control fluid supply of gas or liquid being isolated from the well fluid, for example in control lines or in a parasitic annulus. The valve may include a control fluid piston, application of control fluid thereto tending to close the valve. Preferably, the valve is further also responsive to well fluid pressure, and in particular to the differential well fluid pressure across the valve, such that the closed valve will remain closed or will open in response to a selected control pressure in combination with a selected differential pressure. The valve may include a piston in communication with fluid below the valve and a piston in communication with fluid above the valve; application of pressure to the former may tend to close the valve, while application of pressure to the latter may tend to open the valve. In a preferred embodiment, a selected first control pressure will close

the valve. Such a first control pressure in combination with a higher pressure below the valve will tend to maintain the valve closed. Further, increasing the control pressure will maintain the valve closed in response to a higher pressure above the valve. This facility also allows the applied control pressure to be brought to a particular value, the pressure differential across the valve to be minimised and the control fluid pressure then varied to allow the valve to open.

10            Preferably, the valve is a ball valve.

             Preferably, the valve comprises two valve closure members, and most preferably two ball valves. The valves may have independent operating mechanisms. The valve closure members may close simultaneously, or in sequence, and preferably the lowermost valve member closes first. This allows the valves to be pressure-tested individually. Sequenced closing may be achieved by, for example, providing the valve members in combination with respective spring packs with different pre-loads.

20            Preferably, the valve is run into a cased bore on intermediate or parasitic casing, thus defining a parasitic annulus, between the existing casing and the parasitic casing, via which control pressure may be communicated to the valve. The parasitic casing is sealed to the bore-lining casing at or below the valve, typically using a packer or other sealing arrangement. The parasitic annulus

25

may be used to carry fluids, for example to allow nitrogen injection in the well below the valve. For example, additional casing may be hung off below the valve to extend the parasitic annulus, and a pump open\pump closed nitrogen injection valve provided to selectively isolate the parasitic annulus from the well bore annulus. In other embodiments the parasitic annulus may be utilised to carry gas or fluid lift gas or fluid to a point in the well above the valve, or even between a pair of valves. One or more one-way valves may be provided and which may be adapted to open at a parasitic pressure in excess of that required to close the valve or perform pressure tests above the valve. Such an arrangement may be utilised to circulate out a column of well kill fluid, prior to opening the valve, or alternatively to inject a fluid slug prior to opening the valves, or to inject methanol from the parasitic annulus to prevent hydrate formation.

The valve may be configured to allow the valve to be locked open, for example by locating a sleeve in the open valve.

The valve may be configured to permit pump-through, that is, on experiencing a sufficiently high pressure from above, the valve may be moved, for example partially rotated in the case of a ball valve, to permit fluid flow around the nominally closed valve.

According to another aspect of the present invention.

there is provided an apparatus for use in isolating a reservoir of production fluid in a formation, the apparatus comprising:

5 a valve adapted for location in a bore intersecting a production formation and in which the hydrostatic pressure in the bore at the reservoir is normally lower than the formation pressure; and

first valve control means for permitting control of the valve from surface,

10 the valve including two valve closure members, both valve closure members being adapted to hold pressure both from above and from below.

Preferably, the valve closure members are ball valves.

15 Preferably, the valve closure members are independently operable.

These and other aspect of the present invention will now be described, by way of example, with reference to the accompanying drawings, in which:

20 Figure 1 is a schematic illustration of apparatus for use in isolating a reservoir in accordance with a preferred embodiment of the present invention, shown located in a well;

Figure 2 is an enlarged sectional view of valves of the apparatus of Figure 1; and

25 Figure 3 is a further enlarged sectional view of one of the valves of the apparatus of Figure 1.

Reference is first made to Figure 1 of the drawings, which is a schematic illustration of apparatus 10 for use in isolating a reservoir in accordance with a preferred embodiment of the present invention, the apparatus 10 being shown located in a well 12. The illustrated well features three main sections, that is a 17½ inch diameter hole section lined with 13¾ inch diameter casing, a 12¼ inch hole section lined with 9¾ inch casing, and an 8½" inch hole section lined with 7 inch casing; those of skill in the art will of course recognise that these dimensions are merely exemplary, and that the apparatus 10 may be utilised in a wide variety of well configurations. The apparatus 10 is located within the larger diameter first well section and comprises upper and lower valves 14, 16. As will be described, the valves 14, 16 are similar, with only minor differences therebetween. The valves are mounted on tubing 18 which extends from the surface, through a rotating blow-out preventer (BOP) 20, an annular preventer 22, and a standard BOP 24. An intermediate tubular connector 26 joins the valves 14, 16, and a further section of tubing 28 extends from the lower valve 16, through the 9¾ inch casing, to engage and seal with the upper end of the 7 inch casing. Thus, an isolated annulus 30 is formed between the valves 14, 16 and the tubing 18, 28, and the surrounding casing; this will be referred to as the parasitic annulus 30.

The apparatus 10 will be described with reference to an under-balanced drilling operation, and in such an application a tubular drill string will extend from surface through the valves 14, 16 and the tubing 18, 28.

5       Reference is now also made to Figure 2 of the drawings, which is an enlarged sectional view of the valves 14, 16, shown separated. Reference will also be made to Figure 3 of the drawings which is an enlarged sectional view of the lower valve 16. As the only differences  
10       between the valves 14, 16 is the pre-loading on the valve closing spring and the arrangement of porting for valve control fluid, only one of the valves 16 will be described in detail, as exemplary of both. The valve 16 is a ball valve and therefore includes a ball 34 located within a  
15       generally cylindrical valve body 36, and in this example the ends of the body 36 feature male premium connections 38 for coupling to the tubing section 18 and the connector 26.

      The ball 34 is mounted in a ball cage 40 which is axially movable within the valve body 36 to open or close  
20       the valve. The valve 16 is illustrated in the closed position. Above the cage 40 is an upper piston 42 which is responsive to fluid pressure within the tubing 18 above the valve 14, communicated via porting 43. Further, a power spring 44 is located between the piston 42 and a top plate  
25       46 which is fixed relative to the valve body 36. Accordingly, the spring 44, and fluid pressure above the

ball 34, will tend to move the valve ball 34 to the open position.

Below the cage 40 is a lower piston 48 which, in combination with the valve body 36, defines two piston areas, one 50 in fluid communication with the parasitic annulus 30, via porting 51, and the other 52 in communication, via porting 53, with the tubing below the valves 14, 16, that is the reservoir pressure.

In use, in the absence of any pressure applied to the valves 14, 16 via the parasitic annulus 30, the springs 44 will urge the valve balls 34 to the open position, allowing flow through the valves 14, 16. If however it is desired to close the valve, the pressure in the parasitic annulus 30 is increased, to increase the force applied to the parasitic pistons 50. The pre-load on the spring 44 in the lower valve 16 is selected to be lower than the pre-load of the spring 44 in the upper valve 14, such that the lower valve 16 will close first. Thus, the effectiveness of the seal provided by the lower valve 16 may be verified. A further increase in pressure in the parasitic annulus 30 will then also close the upper valve 14.

The valve balls 34 are designed to permit cutting or shearing of lightweight supports such as slickline, wireline or coiled tubing, passing through the apparatus 10, such that the valves may be closed quickly in an emergency situation without having to withdraw a support

form the bore.

With the valves 14, 16 closed, the reservoir is now isolated from the upper section of the well. This facilitates various operations, including the retrieval, making up and running in of tools, devices and their support strings above the apparatus 10, or the circulation of fluids within the upper end of the tubing 18 to, for example, fill the tubing 18 with higher or lower density fluid.

10 In the event that the reservoir pressure below the valves 14, 16 is higher than the pressure in the tubing 18 above the valves 16, 18, the reservoir pressure acting on the pistons 52 will tend to maintain the valves 14, 16 closed, thus preventing uncontrolled flow of formation fluids from the reservoir.

15 In the event that the pressure differential is reversed, that is the pressure force above the valves 14, 16 is greater than the reservoir pressure acting below the valves 14, 16, the parasitic pressure may be increased to increase the valve closing force acting on the pistons 50, to counteract the valve opening force acting on the pistons 42.

20 The area of the upper piston 42 is equal to the combined areas of the parasitic and reservoir pistons 50, 52, while the parasitic piston 50 is larger than the reservoir piston 52. Thus, if it is desired to open the



valve from a closed position, this is normally achieved by increasing the pressure in the parasitic annulus 30 to a point where the parasitic pressure is substantially similar to the reservoir pressure. The pressure in the tubing 18 is then increased, and as the tubing pressure approaches the reservoir pressure the forces acting on the pistons 42 reach a level similar to the oppositely acting forces on the lower pistons 48, such that the springs 44 will tend to open the valves when the parasitic pressure is vented at surface.

While the parasitic pressure remains vented, the springs 44 will retain the valves open.

With this arrangement it would be possible to open the valves when the tubing pressure above the valves 14, 16 was lower than reservoir pressure, if the parasitic pressure was not increased to be greater or equal to the reservoir pressure. However, this would result in the valves 14, 16 opening with a pressure differential, and the resulting rapid flow of fluid through the valves would bring an increase likelihood of erosion and damage to the valves and upstream equipment.

In the event that one or both of the valves cannot be opened, and it is desired to, for example, "kill" the well, if sufficient tubing pressure is applied from surface the valve balls 34 will be pushed downwardly to an extent that kill fluid may pass around the balls 34 and then out of

pump-through ports 54 provided in the lower ball seats 56.

If desired, one or more one-way valves may be provided in the tubing 28 or valve body 36. For example, one or more one-way pressure relief valves may be provided above the upper valve 14, and configured to pass gas or fluid from the parasitic annulus into the tubing 18. Such a valve positioned just above or between the valves 14, 16 may be used to, for example, circulate out a column of well kill fluid prior to opening the valve, or to inject a fluid slug prior to opening the valves. Such a valve could also be used to inject methanol from the parasitic annulus 30 on top of the upper valve 14 to prevent hydrate formation. Alternatively, a one-way valve could be incorporated between the valves 14, 16. Of course, such a valve or valves would only open in response to a parasitic annulus pressure in excess of that required to close the valves, to perform a pressure test from above a closed valve, or to support a column of well kill fluid above the valves.

In the illustrated embodiment the provision of the parasitic annulus may also be used to advantage to, for example, allow nitrogen injection in the well below the apparatus 10. For example, a nitrogen injection point could be provided on the tubing 28 below the apparatus 10. Of course the injection point would have to be isolated from the tubing bore using a pump open\pump close nitrogen injection valve.

From the above description it will be apparent to those of skill in the art that the apparatus described above provides a safe and convenient method of isolating a reservoir, and the ability of the valves to hold pressure from both above and below is of considerable advantage to the operator, and provides additional safeguards and convenience in under-balanced drilling, at balance drilling or live well\light weight intervention environments, most particularly in the deployment of drilling assemblies, intervention assemblies, workover assemblies, completions, liners, slotted liners or sandscreens.

Those of skill in the art will also recognise that the illustrated embodiment is merely exemplary of the present invention, and that various modifications and improvements may be made thereto without departing from the scope of invention. For example, rather than controlling the operation of the valves 14, 16 via the parasitic annulus 30, conventional control lines may be run from surface to supply control fluid to the valves. Further, rather than providing valves in individual housings, a common housing assembly for both valves could be provided. The above described valve arrangements rely primarily on metal-to-metal seals between the balls and the valve seats, and of course in other embodiments elastomeric seals may also be provided.

**CLAIMS**

1. A method of isolating a reservoir of production fluid in a formation, the method comprising:

5 providing a valve in a bore intersecting a production formation and in which the hydrostatic pressure in the bore at the reservoir is normally lower than the formation pressure; and

10 controlling the valve from surface such that the valve will only move from a closed configuration to an open configuration on experiencing a predetermined differential pressure thereacross.

2. The method of claim 1, wherein the valve is moved from an open configuration to a closed configuration by application of a control pressure thereto.

15 3. The method of claim 1, wherein the valve is controlled such that it will only open when there is little or no pressure differential across the valve.

4. The method of claim 3, wherein the bore is in an underbalanced or live well.

20 5. The method of any of the preceding claims, wherein the

closed valve is controlled to hold higher pressure above the valve.

6. The method of any of the preceding claims, wherein the closed valve is controlled to hold higher pressure below  
5 the valve.

7. The method of any of the preceding claims, wherein the closed valve is controlled to hold pressure from both sides.

8. The method of any of the preceding claims, wherein the  
10 valve is positioned above the pressure balance point in the bore.

9. The method of any of claims 1 to 7, wherein the valve is positioned at the pressure balance point.

10. The method of any of claims 1 to 7, wherein the valve  
15 is positioned below the pressure balance point.

11. The method of any of the preceding claims, wherein the valve is controlled from surface by fluid pressure.

12. The method of any of the preceding claims, wherein the control fluid supply is supplied from surface to the

valve through at least one control line.

13. The method of any of claims 1 to 11, wherein the control fluid supply is supplied from surface to the valve through a parasitic annulus.

5 14. The method of any of the preceding claims, wherein the valve is initially open and comprising the step of applying a selected first control pressure to close the valve.

10 15. The method of claim 14, comprising applying a higher pressure below the valve to maintain the valve closed, without continued application of said control pressure.

16. The method of claim 14, comprising applying said first control pressure in combination with a higher pressure below the valve to maintain the valve closed.

15 17. The method of claim 14, 15 or 16 comprising increasing said control pressure to maintain the valve closed in response to a higher pressure above the valve.

20 18. The method of any of claims 14, 15, 16 or 17, comprising bringing the applied control pressure to a particular value, minimising the pressure differential across the valve, and then varying the control fluid

pressure to open the valve.

19. The method of any of the preceding claims, comprising providing two similar valves in the bore.

5 20. The method of claim 19, further comprising closing the valves simultaneously.

21. The method of claim 19, further comprising closing the valves in sequence.

22. The method of claim 21, further comprising closing the lowermost valve first.

10 23. The method of claim 22, comprising pressure testing the lowermost valve following closing thereof and then pressure testing the upper valve following closing thereof.

15 24. The method of any of the preceding claims, comprising running the valve into a cased bore on intermediate or parasitic casing, thus defining a parasitic annulus between the existing casing and the parasitic casing.

25. The method of claim 24, further comprising sealing the parasitic casing to the bore-lining casing at or below the valve.

26. The method of claim 25, further comprising carrying fluids into the bore below the valve through the parasitic annulus.

27. The method of claim 26, wherein the fluid is nitrogen and the nitrogen is injected in the bore below the valve.

28. The method of claim 25 or 26, further comprising hanging additional casing off below the valve to extend the parasitic annulus.

29. The method of claim 25, further comprising carrying gas, fluid lift gas or fluid to a point in the bore above the valve.

30. The method of any of claims 25 to 29, further comprising providing at least one one-way valve between the parasitic annulus and the bore and opening the one-way valve in response to a parasitic pressure in excess of that required to function the valve or perform pressure tests on the valve.

31. The method of claim 30, further comprising circulating out a column of well kill fluid above the valve via the parasitic annulus and the one-way valve prior to opening the valve.



32. The method of claim 30, further comprising injecting a fluid slug via the parasitic annulus and the one-way valve prior to opening the valve.

5 33. The method of claim 30, further comprising injecting methanol from the parasitic annulus to prevent hydrate formation.

34. The method of any of the preceding claims, further comprising locking the valve open.

10 35. An apparatus for use in isolating a reservoir of production fluid in a formation, the apparatus comprising:  
a valve adapted for location in a bore intersecting a production formation and in which the hydrostatic pressure in the bore at the reservoir is normally lower than the formation pressure;

15 first valve control means for permitting control of the valve from surface; and

second valve control means for permitting control of movement of the valve from a closed to an open configuration in response to a predetermined differential pressure across the valve.

20

36. The apparatus of claim 35, the first valve control means is operable to move the valve from the open

configuration to the closed configuration.

37. The apparatus of claim 35, wherein the valve is adapted to hold pressure from at least one side.

5 38. The apparatus of claim 37, wherein the valve is adapted to hold pressure from both sides.

39. The apparatus of any of claims 35 to 38, wherein the first valve control means is responsive to control fluid pressure.

10 40. The apparatus of claim 39, in combination with at least one control fluid-carrying control line for extending between the apparatus and surface.

41. The apparatus of claim 39, in combination with a parasitic casing for defining a control fluid-carrying parasitic annulus.

15 42. The apparatus of any of claims 35 to 41, wherein the first fluid control means includes a control fluid piston, application of control fluid thereto tending to actuate the valve.

43. The apparatus of any of claims 35 to 42, wherein the

second fluid control means includes a piston in communication with fluid below the valve and a piston in communication with fluid above the valve.

5 44. The apparatus of claim 43, wherein application of pressure to the piston in communication with fluid below the valve tends to close the valve member.

45. The apparatus of claim 43 or 44, wherein application of pressure to the piston in communication with fluid above the valve tends to open the valve.

10 46. The apparatus of any of claims 35 to 45, wherein the valve is a ball valve.

47. The apparatus of any of claims 35 to 46, wherein the valve comprises two valve closure members.

15 48. The apparatus of claim 47, wherein the valve comprises two ball valves.

49. The apparatus of claim 47 or 48, wherein the valves have independent operating mechanisms.

50. The apparatus of claim 49, wherein the valves comprise respective valve members in combination with respective

spring packs with different pre-loads.

51. The apparatus of any of claims 35 to 50, wherein the valve is configured to allow the valve to be locked open.

5 52. The apparatus of any of claims 35 to 51, wherein the valve is configured to permit pump-through when in the closed configuration.

53. An apparatus for use in isolating a reservoir of production fluid in a formation, the apparatus comprising:

10 a valve adapted for location in a bore intersecting a production formation and in which the hydrostatic pressure in the bore at the reservoir is normally lower than the formation pressure; and

first valve control means for permitting control of the valve from surface,

15 the valve including two valve closure members, both valve closure members being adapted to hold pressure both from above and from below.

54. The apparatus of claim 53, wherein the valve closure members are ball valves.

20 55. The apparatus of claim 53 or 54, wherein the valve closure members are independently operable.



Application No: GB 0025515.8  
Claims searched: 1-52

Examiner: Nicholas Mole  
Date of search: 3 December 2001

## Patents Act 1977 Search Report under Section 17

### Databases searched:

UK Patent Office collections, including GB, EP, WO & US patent specifications, in:

UK Cl (Ed.S): E1F (FGL, FCC, FLP)

Int Cl (Ed.7): E21B 21/08, 21/10 34/10

Other: Online: WPI EPODOC JAPIO

### Documents considered to be relevant:

| Category | Identity of document and relevant passage   | Relevant to claims                           |
|----------|---|--|
| X        | GB 2323399 A (SCHLUMBERGER) see esp. page 2 line 12 to page 4 line 10, and page 8 lines 13-18 | 1, 6, 11, 34-37, 39, 51 at least             |
| X        | EP 0915230 A (HALLIBURTON) see esp. paras 28-29   | 1-2, 6, 11-12, 14, 35-37, 39-40, 42 at least |
| X        | US 5971353 (JOHNSON) see esp. col. 3 lines 20-63  | 1, 6, 11-12, 35-37, 42 at least              |
| X        | US 5285850 (BAYH) see esp. col. 7 line 67 to col. 9 line 4                                    | 1, 6, 11-12, 35-37, 39-40, 42 at least       |
| X        | US 5251702 (VAZQUEZ) see esp. col. 4 line 9 to col. 5 line 64                                 | 1, 6, 11-12, 35-37, 39-40, 42 at least       |

X Document indicating lack of novelty or inventive step  
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A Document indicating technological background and/or state of the art.  
P Document published on or after the declared priority date but before the filing date of this invention.  
E Patent document published on or after, but with priority date earlier than, the filing date of this application.



Application No: GB 0025515.8  
Claims searched: 1-52

Examiner: Nicholas Mole  
Date of search: 3 December 2001

| Category | Identity of document and relevant passage   | Relevant to claims                                  |
|----------|---|---|
| X        | US 4201363 (ARENDT) see esp. col. 2 lines 41-68, col. 3 lines 42-59, col. 4 lines 7-28, col. 14 lines 33-49 | 1-2, 6, 11-12, 14-16, 34-37, 39-40, 46, 51 at least |

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